

Work Order ID 134006***134006***

Page 1

Tuesday, June 23, 2015 3:27:27 PM

Item ID: D2611 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Bearing
Start Date: 6/23/15 Start Qty: 10.00 ***10*** Cust Item ID:
Required Date: 6/23/15 Req'd Qty: 10.00 ***10*** Customer:
Reference:

Approvals: Process Plan: MLJ Date: JUN 24 2015 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____
Run Start ***NR1***
Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr								
D2611	Rev C								

100

0.00

100

PURCHASING

Purchasing

Memo

0.00

Purchasing

Issue P/O: 28874 Purchase part as per Dwg D2611 Possible supplier:
McMasterP/N: 63215K34 Material release note required

CZ JUN 24 2015 10

110

Receive & Inspect for Damage & Mat'l Certs

0.00

110

Packaging

Memo

0.00

Packaging

Ensure certificate of conformity is attached

10x Sp 15-06-26

120

QC6- Inspect dimensions to drawing

0.00

120

QC

Memo

0.00

Quality Control

10DAS
38
9-89

JUN 26 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : ☐					

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
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OTHER : _____					

Picklist Print

Tuesday, June 23, 2015 3:27:26 PM

Page 1

Work Order ID: 134006

134006

Parent Item: D2611

D2611

Parent Item Name: Bearing

Start Date: 6/23/15

Required Date: 6/23/15

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev:B99.06.23Re-formatDM
Change to SS; Change Supplier- Rev.C 07.03.14 EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
63215K34		Purchased		No			Each	0.0000		10			
63215K34									**				
Bearing													

10x 80 15-06-26

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

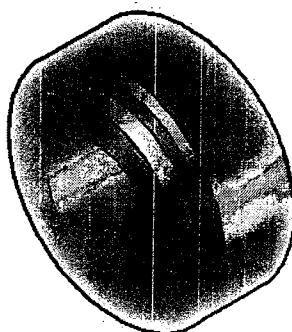
Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
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Root Cause		FAULT CATEGORY							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	OTHER : ☐			



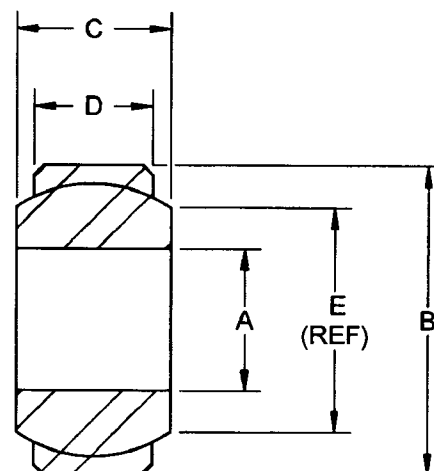
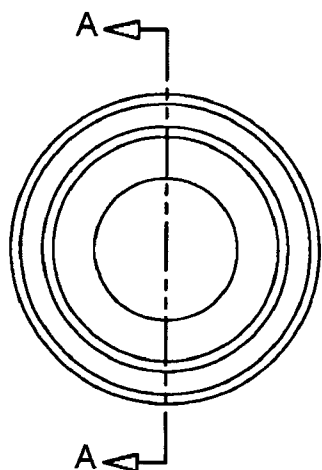
DESIGN <i>qp</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. D2611	REV. C SHEET 1 OF 1
DATE 06.09.20	TITLE BEARING		SCALE NTS
REV	DATE	DESCRIPTION	
A	97.07.31	NEW ISSUE	
B	01.07.04	RE-DRAWN	
C	06.09.20	CHANGE TO SS; CHANGE SUPPLIER	

SPECIFICATION CONTROL DRAWING



RELEASED

06.11.17 *#*



SECTION A-A

SHOT COPY
 APPROVED
 UNCONTROLLED COPY
 SUBJECT TO APPROVAL
 WITH P. 1000
 NO. 134006-MLS
 1506-24



A	B	C	D	E (REF)	POSSIBLE SUPPLIER
0.375	0.813	0.406	0.313	0.592	McMASTER-CARR P/N 63215K34

NOTES:

- 1) STAINLESS STEEL BALL JOINT SWIVEL BEARING
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

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Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO28934**

Purchase Order Date 6/24/2015

PO Print Date 6/24/2015

Page Number 1 of 4

Order From :

VU-MCM001

Ship To : DART AEROSPACE LTD

MCMASTER-CARR SUPPLY CO,
P.O. BOX 7690
CHICAGO, IL 60680-7690
US

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

PAID

Contact Name

Vendor Phone

330 995 5500

Buyer

Chantal Lavoie

Customer POID

Customer Tax #

10127-2607

Ship To Contact

Terms

Net 10

Ship To Phone

Currency

USD

Ship Via:

Purolator ground ppd

FOB

FCA - (Free Carrier)

Ship Acct:

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
1	63215K34 AS PER DWG D2611 REV. C B134006	Bearing	6/26/2015 Yes 6/26/2015		10.00 ✓ Each	\$17.24	\$172.40
Line Total:							\$172.40
2	98470A133 AS PER DWG D4811 REV. A B134005	Pin, Quick Release	6/26/2015 Yes 6/26/2015		10.00 Each	\$3.01	\$30.10
Line Total:							\$30.10
3	9928K53 AS PER DWG D4287 REV. A B133932	UHMW U-Channel	6/26/2015 Yes 6/26/2015		48.00 f	\$2.28	\$109.44

Note:

6/24/2015

200 Aurora Industrial Pkwy
Aurora OH 44202-8087
330-995-5500
cle.sales@mcmaster.com

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury ON K6A 1K7
Canada
Attention: Jean-Luc
Eric.L

Purchase Order
PO28934
Order Placed By
Chantal Lavoie
McMaster-Carr Number
5170960-03

Page 1 of 1

06/24/2015

Line	Product	Ordered	Shipped
1	63215K34 Stainless Steel Ball Joint Swivel Bearing, PTFE Lined, 3/8" ID, 13/16" OD, 13/32" Ball Thick Your Part Number: B134006	10 Each	10
2	98470A133 18-8 Stainless Steel Shoulder-Style Quick-Release Pin, Ring Grip, 1/4" Diameter, 1.3" Usable Length Your Part Number: B134005	10 Each	10
4	97787A661 Expanding Diameter Quick-Release Pin, 1/4" Diameter, 1" Usable Length Your Part Number: B133900	6 Each	6
5	59915K274 PTFE-Lined Stainless Steel Ball Joint Rod End, 3/8"-24 Right-Hand Male Shank, 3/8" Ball ID, 1-1/4" L Thread Your Part Number: B133948	8 Each	8
6	2326A11 Plug Gauge Set, Class Z, .0110"-.0600" Range, Go Gauge, 50 Pieces Your Part Number: 71500-30	1 Each	1
7	2846A129 Single-Flute High-Speed Steel Countersink, 82 Degree Angle, 1-1/4" Body Diameter, 1/2" Shank Diameter Your Part Number: 71500-30	1 Each	1
8	91732A211 18-8 Stainless Steel Standard Helical Insert, 10-24 Internal Thread, .285" Length, MS122120, Packs of 10 Your Part Number: 71500-15	30 Packs	30
9	4714A405 High Performance Multipurpose Sanding Belt, 50 Grit, 3/4" Wide, 20-1/2" Long Your Part Number: 71500-15	25 Each	19

Shipped separately from our Chicago warehouse on 06/24

9	4714A405 High Performance Multipurpose Sanding Belt, 50 Grit, 3/4" Wide, 20-1/2" Long	25 Each	6
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McMaster-Carr Supply Company
 200 Aurora Industrial Pkwy
 Aurora, OH 44202-8087 USA
 Phone: 330-995-5500 Fax: 330-995-9600
 E-Mail: cle.sales@mcmaster.com
 Employer Identification Number (EIN): 36-1458720

Invoice: 33018649
 Purchase Order: PO28934
 Release:
 McMaster-Carr Number: 5170960-03

ORIGINAL COMMERCIAL
INVOICE
 CERTIFICATE OF ORIGIN

Ultimate Destination:
 Dart Aerospace Ltd
 1270 Aberdeen St
 Hawkesbury ON K6A 1K7
 Canada

Shipped: 24-Jun-2015 FOB: ORIGIN
 Shipper's Export Declaration (SED):
 NO EEI 30.36

Intermediate Consignee:

Bill To:
 Dart Aerospace Ltd
 1270 Aberdeen St
 Hawkesbury ON K6A 1K7
 Canada

Tax Number:

Forwarding Agent:

Billing
 Attention:
 Shipping Jean-Luc
 Attention: Eric.L
 Contact:

Line	Description	Qty & Unit	Unit Price	Extension
1	63215K34 Stainless Steel Ball Joint Swivel Bearing, PTFE Lined, 3/8" ID, 13/16" OD, 13/32" Ball Thick B134006 Country of Origin: Peoples Republic of China Schedule B #: 848330 ECCN #: EAR99 NLR	10 EA	\$17.24	\$172.40
2	98470A133 18-8 Stainless Steel Shoulder-Style Quick-Release Pin, Ring Grip, 1/4" Diameter, 1.3" Usable Length B134005 Country of Origin: United States Schedule B #: 731829 ECCN #: EAR99 NLR	10 EA	\$3.01	\$30.10
4	97787A661 Expanding Diameter Quick-Release Pin, 1/4" Diameter, 1" Usable Length B133900 Country of Origin: United States Schedule B #: 731829 ECCN #: 9A991 NLR	6 EA	\$114.68	\$688.08
5	59915K274 PTFE-Lined Stainless Steel Ball Joint Rod End, 3/8"-24 Right-Hand Male Shank, 3/8" Ball ID, 1-1/4" L Thread B133948 Country of Origin: United States Schedule B #: 848330 ECCN #: EAR99 NLR	8 EA	\$17.14	\$137.12
6	2326A11 Plug Gauge Set, Class Z, .0110"-.0600" Range, Go Gauge, 50 Pieces 71500-30 Country of Origin: United States Schedule B #: 903180 ECCN #: EAR99 NLR	1 EA	\$81.70	\$81.70
Your order is subject only to our terms and conditions, available at www.mcmaster.com or from our Sales Department. These commodities, technology, or software were exported from the United States in accordance with Export Administration regulations. Diversion contrary to US law is prohibited.				

Shipping Weight (in kgs): 3 Number of Packages: 1

Package Dimensions:
 47 X 21 X 17 CM = .017 CUBIC M

Invoice Amounts:
 Merchandise Amount: \$1,323.82
 Canadian GST/HST: \$173.83
 Shipping Charges: \$13.40
 Total (In USD): \$1,511.05

Payment Terms: 2% discount on merchandise only if paid within 10 days, net 30 days

Authorized Signature: *Sarah Weinberg* Date: 24-Jun-2015

Remit payment to: (by wire transfer)
 Bank of America Illinois
 231 S LaSalle
 Chicago, IL 60697
 PO Box 7690
 Chicago, IL 60680-7690 USA
 ABA 071000039 Account 86666-02021
 SWIFT BOFAUS3N

Name: Sarah Weinberg Title: Operations Mgr.